

Work Order ID 132913

Friday, May 15, 2015 10:20:06 AM

132913

wedn
Ship 27 May Page 1

Item ID: D407-559-115

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Stop

NS2

Start Date: 5/15/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/26/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *MC*

Date: *15-5-15* Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9624	REV A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels per PPP D407-559-115 CHG001								
151	Pick Kit	0.00							
151									
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									

DAS 27 9-89

MAY 26 2015

DAS 6 9-89

002

9-89

DAS 27 9-89

MAY 19 2015

DAS 26 9-89

MAY 26 2015

DAS 6 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Page 2

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Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Stop

NS2

Start Date: 5/15/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/26/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

DAS
6
9-89

APR 26 2015

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ

MAY 26 2015

ME

15-5-26

DQA: _____ Date: _____



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Picklist Print

Friday, May 15, 2015 10:20:05 AM

Page 1

Work Order ID: 132913

132913

Parent Item: D407-559-115

D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 5/15/2015

Required Date: 5/26/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-07-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2274

Manufactured No

Each

543.0000

12 24

D2274

Radius Block

DAS

6

9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

396

127579

384

129934

12

ST012a

135

131031

135

Manufactured No

Each

122.0000

12 24

D2529

D2529

Washer

DAS

6

9-89

Location

Loc Qty

Loc Code

ST008

122

128950

122

Manufactured No

Each

1.0000

12 24

D2432-3

D2432-3

206 (24") Bearpaw

DAS

6

9-89

Location

Loc Qty

Loc Code

ST476

1

119506

1

B132914

12 24

MAY 26 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Friday, May 15, 2015 10:20:05 AM

Page 2

Work Order ID: 132913

132913

Parent Item: D407-559-115

D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 5/15/2015

Required Date: 5/26/2015

Start Qty: 1.00

Required Qty: 1.00

D4011-1

Manufactured No

Each

78.0000

D4011-1

Clamp, Short

DAS
6
9-89

Rev. C

Location

Loc Qty

Loc Code

ST542

78

130923

18

132221

60

Each

16.0000

6 12
**

DAS
27
9-89

JAS
26
9-89

D4012-1

Manufactured No

Each

16.0000

D4012-1

Cushion

DAS
6
9-89

Rev. C

Location

Loc Qty

Loc Code

FG

5

131213

5

ST545

11

131213

11

Each

117.0000

6 10
**

DAS
27
9-89

DAS
26
9-89

AN4-20A

Purchased No

Each

117.0000

AN4-20A

Bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

51

116419

51

ST325A

1

m131803

1

ST343

65

131677

1

m132189

64

12 24
**

DAS
27
9-89
MAY 15 2015

DAS
26
9-89

Friday, May 15, 2015 10:20:05 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

Friday, May 15, 2015 10:20:05 AM

Page 3

Work Order ID: 132913

Parent Item: D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

132913

D407-559-115

Start Date: 5/15/2015

Required Date: 5/26/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

NAS1149D0463.1

WASHER

DAS
6
9-89

4,308.000

**

12 24

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST269

4267

M129682

86

M130799

371

M132035

3810

Each

3,203.000

**

12 24
24

DAS
27
9-89

DAS
26
9-89

MAY 19 2015

MS21042L4

Purchased

No

MS21042L4

Locknut

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

224

m127813

224

ST260a

1062

m130799

56

m131803

6

m132262

1000

ST305

1875

m128300

8

m130388

7

m130922

97

m131618

12

m132123

1751

12 24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER : _____																																																																				

REFERENCE ONLY

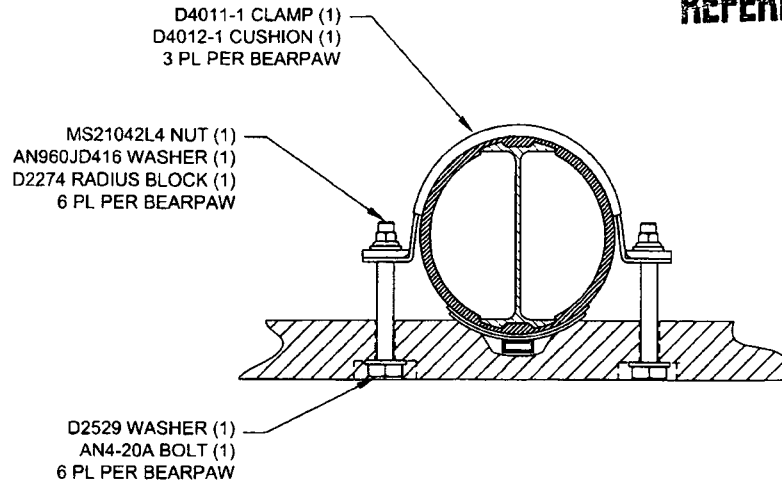


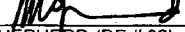
Figure 2 - D4011-1 Clamp Installation

4.0 PARTS LIST

QTY -115	PART NUMBER	DESCRIPTION
1	D407-559-115	BEARPAW INSTALLATION
12	D2274	RADIUS BLOCK
12	D2529	WASHER
2	D2432-3	BEARPAW
6	D4011-1	CLAMP
6	D4012-1	CUSHION
12	AN4-20A	BOLT
12	AN960JD416	WASHER (NAS1149D0463J)
12	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 12.07.05
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	qp	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9624	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	BEARPAW INSTALLATION	NTS
DATE	12.07.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Work Order ID 132913

Friday, May 15, 2015 10:20:06 AM

132913

Ship 27 May ^{wedn} Page 1

Item ID: D407-559-115

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Stop *NS2*

Start Date: 5/15/2015 Start Qty: 1.00 *1*

Required Date: 5/26/2015 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: ME Date: 15-5-15 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9624	REV A								
100	Document Control	0.00	DAD	27	9-09				MW MAY 19 2015
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels per PPP D407-559-115	CHG001							
			002 see attachment						
151	Pick Kit	0.00							
151									
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									

MAY 19 2015

24

4

Description: BEARPAW INSTALLATION

H:\Forms\Engineer\Approved Eng Online\CHGREC revB